



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2888
Job Sheet 178304



Part No: D2888

Job Qty: 6 ea

Part Name: Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/29/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *5th*

Description:

Note: DWG REV A2 IPP C 00.06.22 Removed P/O for powder coat EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		6/22/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	6 pcs		6/22/18	0.00	0.18	Bandsaw1		
110	CNC Vertical Machining	6 pcs		6/22/18	0.70	8.43	HAAS1-2		
120	QC	6 pcs		6/22/18	0.00	0.00	QC2 Machining-1		
130	QC	6 pcs		6/22/18	0.00	0.00	QC8 Machining-1		
140	HandFinish	6 pcs		6/22/18	0.00	0.22	HandFinish1		
150	Powdercoat	6 pcs		6/22/18	0.00	0.23	Powdercoat1		
160	QC	6 pcs		6/22/18	0.00	0.00	QC3		
170	Packaging	6 pcs		6/22/18	0.00	0.00	Packaging3-1		
180	QC21-SA	6 Ea		6/22/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks at 4.200" long ***Grain along 4.200"****

Descriptions: 110 - Machine as per Folio D2888 Dwg Rev:

150 - START TIME: *8:10* FINISH TIME: *8:40. OUT: 320 M178304*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.500X03.500	6061-T6 Bar 2.50 X 3.50	2.3400 ft (.39 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.500X03.500	2	8	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																										
Date :		MRB (QSI042) Approval																																																										
Descript		 Container No: S089824 Part: D2888 Job No: 178304 Serial No/Batch: S089824 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/07/18																																																										
		Completed By																																																										
		Lead hand / Supervisor Approval Verification																																																										
		QC / QA Coordinator Approval																																																										
DART AEROSPACE 1270 Aberdeen Street Haverhill, MA 01830 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART Aerospace Ltd. 1270 Aberdeen Street Haverhill, MA 01830 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																												
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left; padding: 5px;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment</td> <td style="width:15%;">☐</td> <td style="width:15%;">No Re-ver</td> <td style="width:15%;">☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Set</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> </tr> <tr> <td colspan="4" style="padding: 5px;">OTHER : _____</td> </tr> </tbody> </table>					Root Cause				Environment	☐	No Re-ver	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Set	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	OTHER : _____			
Root Cause																																																												
Environment	☐	No Re-ver	☐																																																									
Design	☐	Operator	☐																																																									
Doc/Data	☐	Offset/Set	☐																																																									
Equip/Tooling	☐	Supplier	☐																																																									
Handling/Pre	☐	Training	☐																																																									
Material	☐	Use for Testing	☐																																																									
Internal Transport	☐	Poor Information	☐																																																									
Tribal Knowledge	☐	Rushing	☐																																																									
LOA	☐	Product Improvement	☐																																																									
Substation	☐	Process Improvement	☐																																																									
Past Expiry Date	☐	Manufacturing Process	☐																																																									
Misidentified	☐	Past Due	☐																																																									
OTHER : _____																																																												

DART AEROSPACE LTD		Work Order: 178304
Description: Lug		Part Number: D2888
Inspection Dwg: D2888	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	0.387	✓		Kt-05	Verm.
Ø0.88	+/-0.030	0.880	✓		" "	" "
0.063 x 45°	+/-0.010	0.0625	✓		" "	" "
4.06	+/-0.030	4.060	✓		31006	H-G
Ø0.760	+0.005/-0.000	0.760	✓		Kt-05	Verm.
3.48	+/-0.030	3.480	✓		" "	" "
2.500	+/-0.010	2.500	✓		" "	" "
2.75	+/-0.030	2.750	✓		" "	" "
0.438	+/-0.010	0.438	✓		" "	" "
0.080 x 45°	+/-0.010	0.080 x 45°	✓			
1.85	+/-0.030	1.850	✓		" "	" "
1.000	+/-0.010	1.002	✓		" "	" "
0.425	+/-0.010	0.423	✓		" "	" "
0.030 x 45°	+/-0.010	0.030	✓		" "	" "
1.875	+/-0.010	1.870				
0.375	+/-0.010	0.375	✓		Kt-05	Verm.
R0.25	+/-0.030	0.250	✓			R-G
1.29	+/-0.030	1.290	✓		Kt-05	Verm.
0.414	+/-0.010	0.414	✓		Kt-05	Verm.
3.41	+/-0.030	3.400	✓		31006	H-G

Measured by: Jml	Audited by: J.C.L.	Prototype Approval:	N/A
Date: 18/07/07	Date: 18-07-09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____	